



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 166572



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 10/20/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq In born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	10 Ea	10/18/17	0.00	0.00	Start up container	S.L.
100	DC	10 pcs	10/18/17	0.00	0.00	DC	D.M.L.
110	Large Fab	10 pcs	10/19/17	0.00	9.91	Large Fab 2	S.L. 10/23/17
120	QC	10 pcs	10/19/17	0.00	0.00	QC9	CPL AUG 26 2017
130	QC	10 pcs	10/19/17	0.00	0.00	QC5	CPL
140	HandFinish	10 pcs	10/19/17	0.00	1.84	HandFinish1	JSL 2017-10-26
150	QC	10 pcs	10/19/17	0.00	0.00	QC7	PD 17-11-01
180	Large Fab	10 pcs	10/19/17	0.00	9.91	Large Fab 2	S-BA 11/2/17
190	QC	10 pcs	10/19/17	0.00	0.00	QC10	38 DAS
200	QC	10 pcs	10/19/17	0.00	0.00	QC5	9-88 38
210	HandFinish	10 pcs	10/19/17	0.00	1.84	HandFinish1	2017-11-06 JSL
220	Powdercoat	10 pcs	10/19/17	0.00	2.90	Powdercoat1	RK
230	HandFinish	10 pcs	10/20/17	0.00	1.84	HandFinish3	BBB 11/10/17
240	QC	10 pcs	10/20/17	0.00	0.00	QC3	
250	Packaging	10 pcs	10/20/17	0.00	0.00	Packaging1	SD
260	QC	10 pcs	10/20/17	0.00	0.00	QC4	SMB
270	Packaging	10 pcs	10/20/17	0.00	0.00	Packaging3	SMB
280	QC21-FG	10 Ea	10/20/17	0.00	0.00	QC21	17/11/20 JF

Part Op 100 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Descriptions: 110 - 1-Bevel end for welding FWD ONLY 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272

220 - START TIME: 1.10 FINISH TIME: 1.10

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3067-1	10	79	0	0
	D3219-1	20	153	0	0
	D3272-1	10	3	0	0

QQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: <u>166572</u> Part No. <u>D250-591-311</u> NCR No. <u>19-7324</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☒ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐	
Date: <u>12-10-25</u>		Step #: <u>110</u>		QTY Effective: <u>6</u>		MRB (QS1042) Approval <u>S 12/10/25</u>	
Description Work Order Deviation <u>Found at inspection cracks in weld.</u> <u>R.C. Employee was cooling off welds with air gun after welding causing it to crack.</u>				Disposition <u>Discard no replace</u> <u>Retain</u> <u>Retain Employee not to</u> <u>Perf Perform this,</u> <u>Qty 6 SCRAP</u>			
Completed By <u>19-07-11</u> Lead hand / Supervisor Approval Verification <u>24</u> <u>9-89</u> AUG 25 2017				QC / QA Coordinator Approval <u>25</u> <u>12-10-25</u>			
Root Cause Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☒ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☒ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	
Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☒ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____			

Large Fab

Packaging

FM130
441-40

✓ D3065-041	FI65610	10	48	0	0
✓ D3066-1	FI65744	20	66	0	0
✓ D3067-1	FI65725	10	79	0	0
✓ MS20600-AD4W4	64	160	626	0	0
AN3-35A	500878	20 -8	22	0	0
AN4-13A	500879	80 -32	20	0	0
AN5-36A	500877	20 -8	4	0	0
D2230-3	500876	40 -16	132	0	0
D2618	500875	20 -8	17	0	0
D2856-400-720	500878	20 -2	138	0	0
D3235-1	500730	20	13	0	0
D3278-041	500877	10 -14	27	0	0
MS21042L3	500877	20 -8	462	0	0
MS21042L4	500872	80 -32	1,089	0	0
MS21042L5	500870	20 -8	109	0	0
NAS1149D0363J	500879	40 -16	955	0	0
NAS1149D0463J	500876	160 -64	1,118	0	0
NAS1149D0563J	500876	40 -16	846	0	0

Part Specifications

Specifications could not be found.

Plex 10/11/17 2:49 PM Dart.lajeunesse.marie

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Date: _____

Work Order update only ☐



Work Order: _____

Part No. _____

NCR No. _____

Date: _____ Step # _____

Description Work Ord

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

AGAINST DEPARTMENT/PROCESS

tube	☐	Water Jet	☐	Engineering	☐
l Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
shing	☐	Rec/Store/Packaging	☐	Other	☐
posite	☐	Supplier	☐		☐

Position

MRB (Q51042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

CATEGORY

☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Dimensions
☐	Grain	☐	Over/Under tolerance
☐	Weld	☐	Part Incorrect
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Part Moved
☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread
☐	Misaligned/off center	☐	Turning Sequence

DART
AEROSPACE
S004904



Heli - Access - Step LH - High Gear, Long Step, Aerazur
Float Compatible

D350 - 591 - 311

**QC
4**

Mfg Date: 11/01/17
Job No: 166572

PART NO:
Revision:
Operation:
Quantity:
Change No:

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Wave/Twist in Tube
Marks/Chatter

Drill Holes

OTHER: